

PRODUCT BULLETIN GYPSUM PRODUCTS	GYPSUM VENEER BASE TYPE X SUPER $\frac{1}{2}$ " x 48" WIDE FOR VENEER PLASTER	BULLETIN NO: B-15D DATE: 6-3-75 PAGE: 1 of 4
APPROVALS: <i>[Handwritten signatures]</i>	ASTM C588	CANCELS: B-15D DATE: 1-15-69

<u>Core Formula (lbs/MSF)</u>		<u>Long Beach</u>	<u>Antioch</u>	<u>Seattle</u>	<u>Delanco &amp; Jacksonville</u>
Board Stucco	(S-1, S-2)	1300-1500	1300-1500	1300-1500	1300-1500
Glass Fiber	(B-G-1)	3.8-4.2	3.8-4.2	3.8-4.2	3.8-4.2
Paper Fiber	(B-G-1)	10-12	13-15	10-12	13-15
Vermiculite Ore	(RM-B-28)	70-75	70-75	70-75	70-75
Starch	(B-G-1)	7-10	7-10	7-10	7-10
Dextrose	(RM-B-3)	0-3	0-3	0-3	0-3
Core Foaming Agent:					
ALS	(B-G-1)	0.2-1.7	---	---	0.2-1.7
AAS	(B-G-1)	---	0.2-1.0	0.2-1.0	---
Lignin		none	none	none	none
End Trim	(B-G-1)	20-35	10-30	20-35	20-35
Potassium Sulfate	(B-G-1)	9.5-2.0	0-2.0	0.5-3.0	0.5-2.0
Hydrated Lime	(B-G-1)	0-0.5	0-0.5	0-0.5	0-0.5
Retarder Rosario	(B-G-1)	---	0-0.5	---	---

Paper Liners: Grade 7004 Coreboard paper for both sides. Grade 7002 Greyback paper may be used on back of 48" wide Veneer Base.

Paper shall be free from quick saturation points.

NOTE: Formula is based on U.L. Label Procedure R3543, Section 3.

PRODUCT BULLETIN  
GYPSUM PRODUCTS

GYPSUM VENEER BASE  
TYPE X SUPER  
1/2" X 48" WIDE  
FOR VENEER PLASTER

ASTM C588

BULLETIN NO: 3-150  
DATE: 3/15/71  
PAGE: 2 OF 4  
CANCELS: 3-150  
DATE: 12/1/69

OPERATING SPECIFICATIONS: (Refer to Process Bulletin BG-2 for General Specifications)  
ALL PLANTS

1. Slurry Setting Time (minutes) 2.0-4.5
2. Wet Slurry Weight (lbs./cu.ft.) 72-82
3. Wet Compressive Strength (psi) 235-400
4. Liner Absorption Correction - Apply a 0.5 maximum percent solution of wetting agent (Bulletin RM-B14) by felt to the face of the base as required to meet the face paper absorption specification.
5. Use Flexograph rust orange ink (RM-B21) for face printing as shown on Page 4 of 4.

PRODUCT SPECIFICATIONS: (Refer to Product Bulletin BG-4 for General Specifications)

	<u>All Plants</u>
Wet Weight (Lbs/MSF)	2800-3050
Dry Weight (Lbs/MSF)	1875-2050
Average	1950
Evaporation Loss (Lbs/MSF)	900-1100
Thickness - Average (inch)	.503 minimum
Thickness - Individual reading (inch)	+ .010 from average
Edge Hardness at take-off (lbs.)	8.0 min., 18 max., 13 average
End Peel after Sawing (inch)	1/8 maximum
Flexural Strength, minimum	
Across grain (lbs.)	150
Parallel (lbs.)	60
Deflection at Break, minimum	
Across grain (inch)	0.25
Parallel (inch)	0.15

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GYPSUM VENEER BASE  
TYPE X SUPER  
1/2" X 48" WIDE  
FOR VENEER PLASTER

ASTM C588

BULLETIN NO: B-157  
DATE: 3/15/71  
PAGE: 3 of 4  
CANCELS: B-157  
DATE: 12/1/69

PRODUCT SPECIFICATIONS: (Cont'd.)

	<u>All Plants</u>
Punch Test (lbs.)	800-1200
Twist Test, maximum split	
Face (inch)	3/4
Back (inch)	3/4
Hammer Loss, decigrams	
Individual Test, maximum	5
Bond at High Humidity, maximum peel	
Face (inch)	1/2
Back (inch)	1/2
Absorption Rate, Veneer Base Face (minutes)	3-6
Absorption Rate, Paper Bound Edges (minutes)	2-6
Liner Spread, Veneer Base Face, 16ths of an inch	20-35
Length Tolerance on Specified Length	1/4" under, no over
Width Tolerance on Specified Width	3/32" under, no over.

Edges shall be square; or,  
Edges of the base shall be round tapered edge. The over-all thickness on opposite edges of the base shall check to within .010". See Operating Bulletin B-G-4, page 2 and 3.

Profile - Variations in the surface of the face and back planes shall be not greater than 0.010" in a 6 inch span measured across the width.

Ends of the base shall be cut straight and clean without breaking or damaging the core at the cut.

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BULLETIN NO: B-15D  
DATE: 3/15/71  
PAGE: 4 of 4  
CANCELS: B-15D  
DATE: 4/15/69

PRODUCT SPECIFICATIONS: (Cont'd.)

Surface - Face shall be smooth and free from scuffed areas, blisters, or loose paper plies.  
Minor cockles not over 0.060" or 1/16" deep are permissible on the back surface.

Core Quality - Voids shall be small and uniform in size. Core shall contain no voids more than 1/8" in length by 1/4" in width.

FACE PRINTING SHALL READ: 1/2" TYPE X SUPER KAISER VENEER BASE

(print on one edge)

Note: DO NOT use the Null-A-Fire designation on Veneer Base.

BUNDLING - Bundle two pieces face to face with 3/4" zip tape and bundling tape designated for 4' wide Gypsum Veneer Base Type X Super. Do not use UL Label Bundling Tape.